

Date: Wednesday, 6/6/2007 3:04:40 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PEDAL ASSEMBLY
Job Number : 32822	
Estimate Number : 10504	
P.O. Number : <i>N/A</i>	Part Number : D3204041
This Issue : 6/6/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3204 REV. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : A1
Previous Run : 30829	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/30/2007 Qty: <i>6</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est:C 05.08.11 Added Step 25 KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32041	Tube
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Tube

Pick:

Qty	Part Number	Description	Batch
1	D3204-1	Tube	<i>25031 5x / 23524 1x</i>

(OK)

2.0	D32043	Arm
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
1	D3204-3	Arm	<i>23524 1x / 30895 5x</i>

(OK)

3.0	D32045	Arm
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
1	D3204-5	Arm	<i>23524 1x / 30896 5x</i>

(OK)

4.0	D32049	Pedal
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

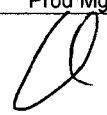
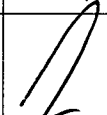
Pedal

Pick:

Qty	Part Number	Description	Batch
1	D3204-9	Pedal	<i>23524 1x / 30897 5x</i>

(OK)

(PTO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/07/05	5.i	Δ 3204-13 Gusset	B23524 x6 permenant change	MA	07/07/05	6	  07-07-20

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 32822

Part Number: D3204041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D320411

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Plate

Pick:

Qty Part Number Description  
1 D3204-11 Plate

Batch

30894

OK

07/07/05 JS

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.

2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld.

3- Use JB weld compound to plug the hole after assembly.

4- Grind JB weld flush after it is cured.

Identify as D3204-041

07/07/06 JS

07/07/06 JS

(weld) 07/07/06 JS

07/07/06 JS

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/09

(6)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/09

(6)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL

07/07/10

(6)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

\*\*\*Cover holes for bushing\*\*\*

m 104846

BR/FL

07-07-10

(6)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

JS

07/07/18

(6)

(P70) →

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3204-041 PAR #: N/A Fault Category: Prod - LG. FAB NCR: Yes No DQA: HA Date: 07.07.20  
 QA: N/C Closed: HA Date: 07.07.23

NCR: 32822		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<del>07/07/18</del>	<del>20</del>	<del>Screen and destroy</del>		<del>destroy</del>	<del>SAO</del>	<del>07/07/18</del>	<del>En</del>	<del>07/07/18</del>
07/07/18	20	1 part (whole ass) Screen. holes are elongated	AS1012	screen and destroy no replace	SAO 07/07/18	En 07/07/18	AS1012	En 07/07/18

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 3:04:40 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 32822

Part Number: D3204041

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

D32047

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bushing

Pick:

Qty

Part Number

Description

Batch

2

D3204-7

Bushing

B23524 (2)

B24722 (10)

SB 07/07/13 (6)

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install D3204-7 bushing as shown in Dwg D3204

SB 07/07/18 (5) FB

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/07/18 (5)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8/7/19 (5)

SD

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.20 (5)

Job Completion



u 07.07.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

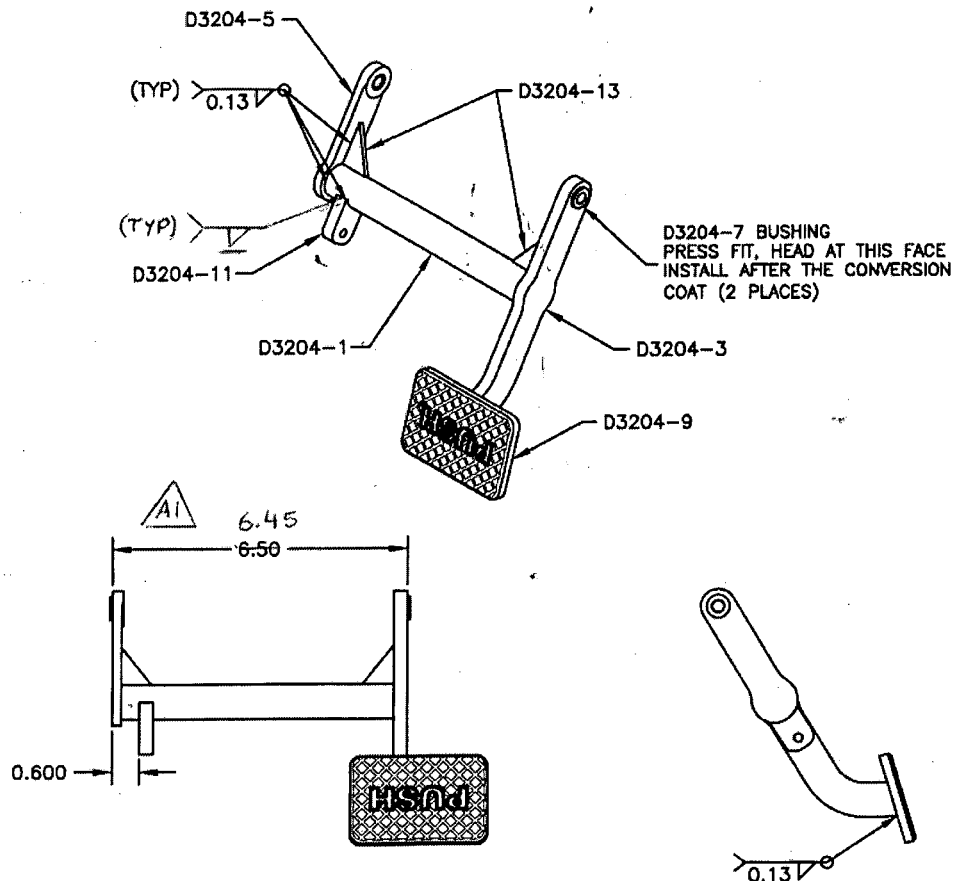
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED  
04.04.30



**D3204-041 RELEASE PEDAL ASSEMBLY**

**NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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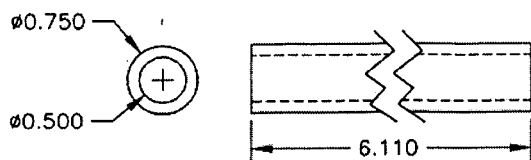
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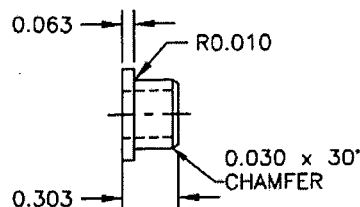


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DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

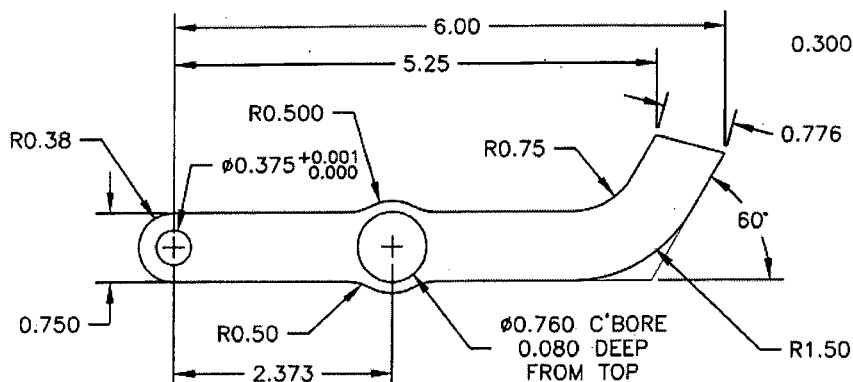
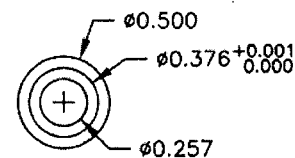
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04.04.05 [Signature]



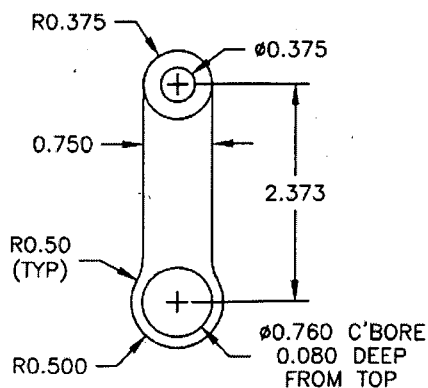
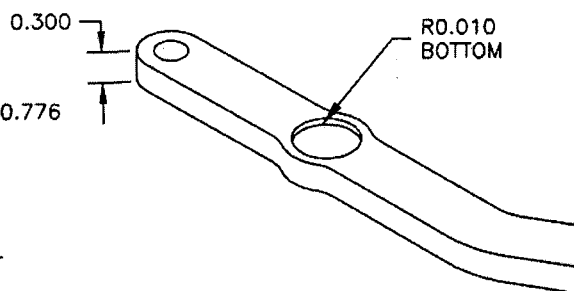
2 D3204-1 TUBE  
SCALE 1:2



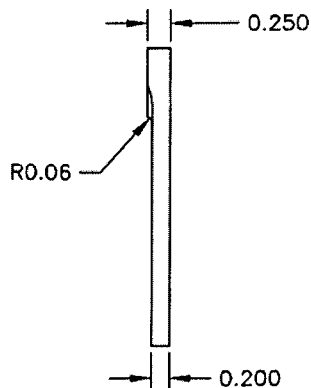
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



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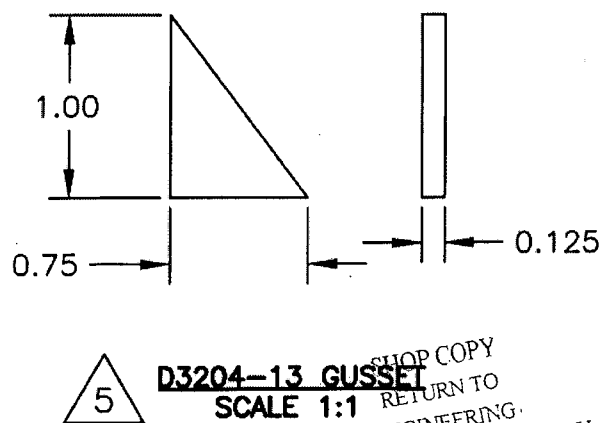
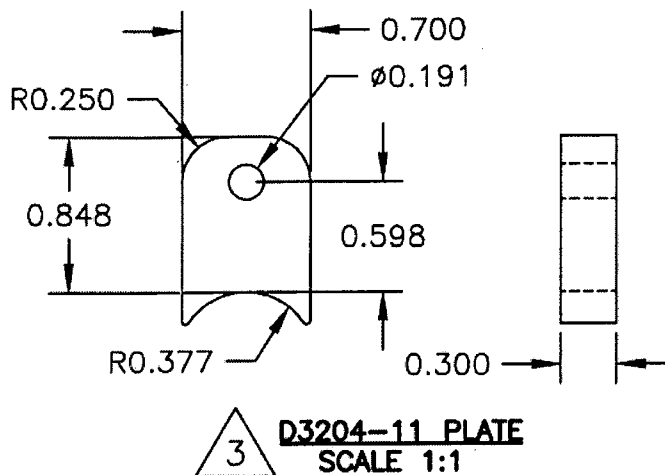
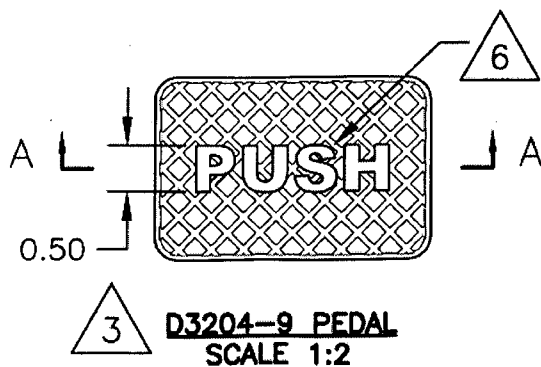
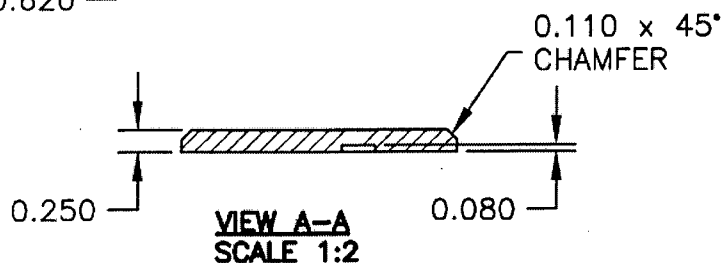
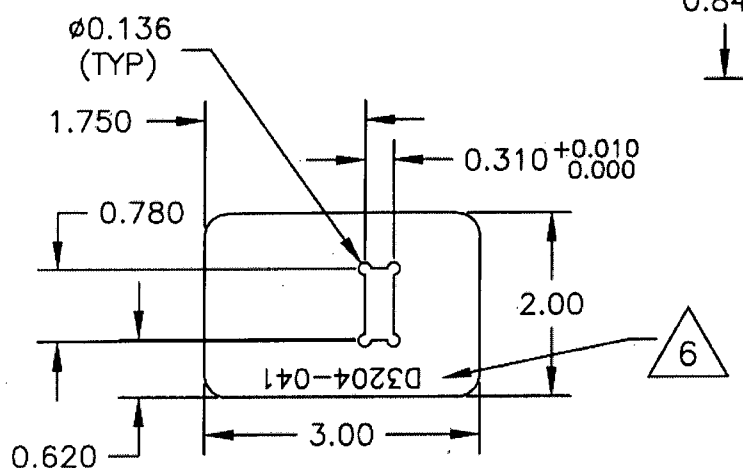
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